

**Work Order ID 59357**

Wednesday, June 02, 2010 11:58:52 AM



Page 1

Item ID: D3908-041

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Assembly, Aft

Stop



Start Date: 6/2/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/3/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MP

Date: 10-6-02

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3908	C

100 Pick Kit

0.00



Packaging

Memo

0.00

110



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg  
TRIM RIVETS 1.185" LONG

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 6/3/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Identify as per dwg &amp; Stock Location:

0.00

*6/6/13 21*

Packaging

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

*10/06/03 AJ**U 10-06-03*

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# Picklist Print

Wednesday, June 02, 2010 11:58:51 AM

Page 1  
4

Work Order ID: 59357



Parent Item: D3908-041



Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 6/2/2010

Required Date: 6/3/2010

Comments: IPP RevA: New issue DD verified by:EC  
As per Rev B 10-04-06 VERIFIED BY:DD  
10.05.27 DD verf:EC  
10.05.28 DD verf:EC

IPP REV B:  
IPP Rev:C as per PC1  
IPP Rev:D per ECN10-581

Start Qty: 2.00

Required Qty: 2.00

D2690-6



Manufactured

No

100

Each

18.0000

1

2

EP10/06/02

Lanyard Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST021	18	
58375	18	

D3908-1



Manufactured

No

100

Each

15.0000

2

4

Lug Plate, Aft Crosstube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST095	15	
58344	11	
59247	4	

D3908-3



Manufactured

No

100

Each

2.0000

1

2

Stud Receiver, Lower

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST095	2	
57816	2	

D3908-5



Manufactured

No

100

Each

11.0000

1

2

Eyebolt Stud

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

GA	1	
57428	1	
ST095	10	
58850	10	

58840 x 2 MFT 10-6-2

2 MFT 10-6-2

10-6-2

W/O:		WORK ORDER CHANGES					
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IPP REV B:  
IPP Rev:C as per PC1  
IPP Rev:D per ECN10-581

Start Qty: 2.00

Required Qty: 2.00

D3910-1



Manufactured

No

100

Each

13.0000



Crosstube Lug

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

st507	13	
-------	----	--

58341	13	
-------	----	--

42  
EpS10/06/02

D4091-1



Manufactured

No

100

Each

3.0000



Mounting Lug

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST460	3	
-------	---	--

58098	3	
-------	---	--

2  
EpS10/06/02

AN3C12A



Purchased

No

100

Each

130.0000



Bolts

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST351	130	
-------	-----	--

112314	80	
--------	----	--

114761	50	
--------	----	--

2  
EpS10/06/02

AN4C13A



Purchased

No

100

Each

133.0000



BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST357	133	
-------	-----	--

113359	20	
--------	----	--

114108	13	
--------	----	--

114442	50	
--------	----	--

114615	50	
--------	----	--

4  
2  
EpS10/06/02

W/O:		WORK ORDER CHANGES					
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10.05.27 DD verf:EC  
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IPP REV B:  
IPP Rev:C as per PC1  
IPP Rev:D per ECN10-581

Start Qty: 2.00

Required Qty: 2.00

MS17984-C413

Purchased

No

100

Each

21.0000

1



PIN, QUICK RELEASE



EF 10/06/02

Location Loc Qty Loc Code

ST297 4

114340 4

ST314 17

114523 1

114774 16

100 Each 273.0000

6

2

12

EF 10/06/02

M 114808 (ex)

MS20615-4M20

Purchased

No

100

Each

273.0000



RIVET

Location Loc Qty Loc Code

ST323 273

113254 7

114324 4

114349 62

114808 200

MS21043-3

Purchased

No

100

Each

3,451.000



Nut

Location Loc Qty Loc Code

FG 80

103691 80

ST301 3371

112314 3371



4

1

2

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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10.05.27 DD verf:EC  
10.05.28 DD verf:EC

IPP REV B:  
IPP Rev:C as per PC1  
IPP Rev:D per ECN10-581

Start Qty: 2.00

Required Qty: 2.00

MS21043-4	Purchased	No	100	Each	1,597.000	1	2	<i>E/S 10/06/02</i>

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	40	
104603	40	
ST301	1557	
112492	25	
113069	8	
114181	224	2
114348	500	
114523	500	
114784	300	

NAS1149C0332R	Purchased	No	100	Each	1,594.000	4	8	<i>E/S 10/06/02</i>

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	1594	
113524	10	
113737	150	
114341	1434	8

NAS1149C0432R	Purchased	No	100	Each	766.0000	2	4	<i>E/S 10/06/02</i>

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	766	
114292	166	
114742	600	4

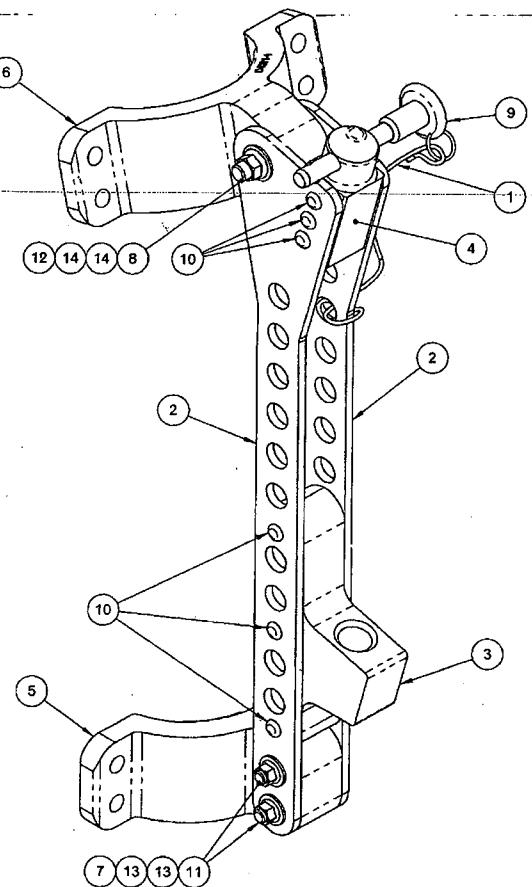
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	1	D3910-1	X-TUBE LUG
6	1	D4091-1	MOUNTING LUG
7	2	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	6	MS20815-4M20	RIVET
11	2	MS21043-3	NUT
12	1	MS21043-4	NUT
13	4	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER



**D3908-041 X-TUBE LUG ASSY (AFT)**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.34 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

C	REDESIGNED ITEM #2; ITEM #6 REPLACES QTY 1 ITEM #5; QTY 2 FOR ITEMS #7 & 11 WAS QTY 4; QTY 8 FOR ITEM #13 WAS 4, ADDED ITEMS #8, 12 & 14		MB	10.05.27
B	BCM: D3909-5 REPLACED WITH D3908-5. QTY 1 ADDED: D2690-6 & MS17984-C413. SHEET 6: ADDED D3908-5	JPH	10.04.06	
A	NEW ISSUE	JPH	10.03.04	
REV.	DESCRIPTION	BY	DATE	
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN		DRAWING NO.	REV. C D3908 SHEET 1 OF 5	
CHECKED		MFG. APPR.	TITLE X-TUBE LUG ASSY (AFT)	
APPROVED		DE APPR.	SCALE	NTS
DATE	10.05.27			

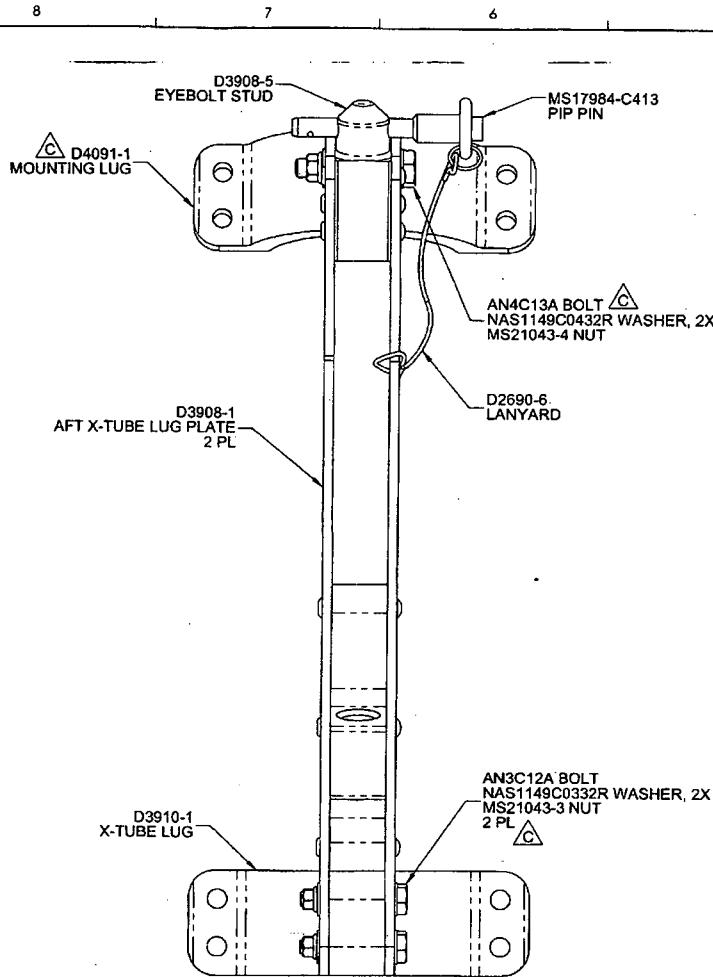
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3908-041 X-TUBE LUG ASSY (AFT)

5

4

3

2

1

8

7

6

5

4

3

2

1

RELEASED  
2010-05-28  
JWD

DESIGN	JFH	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3908
MFG. APPR.		REV. C
APPROVED		SHEET 2 OF 5
DE APPR.		TITLE X-TUBE LUG ASSY (AFT)
DATE	10.05.27	SCALE NTS

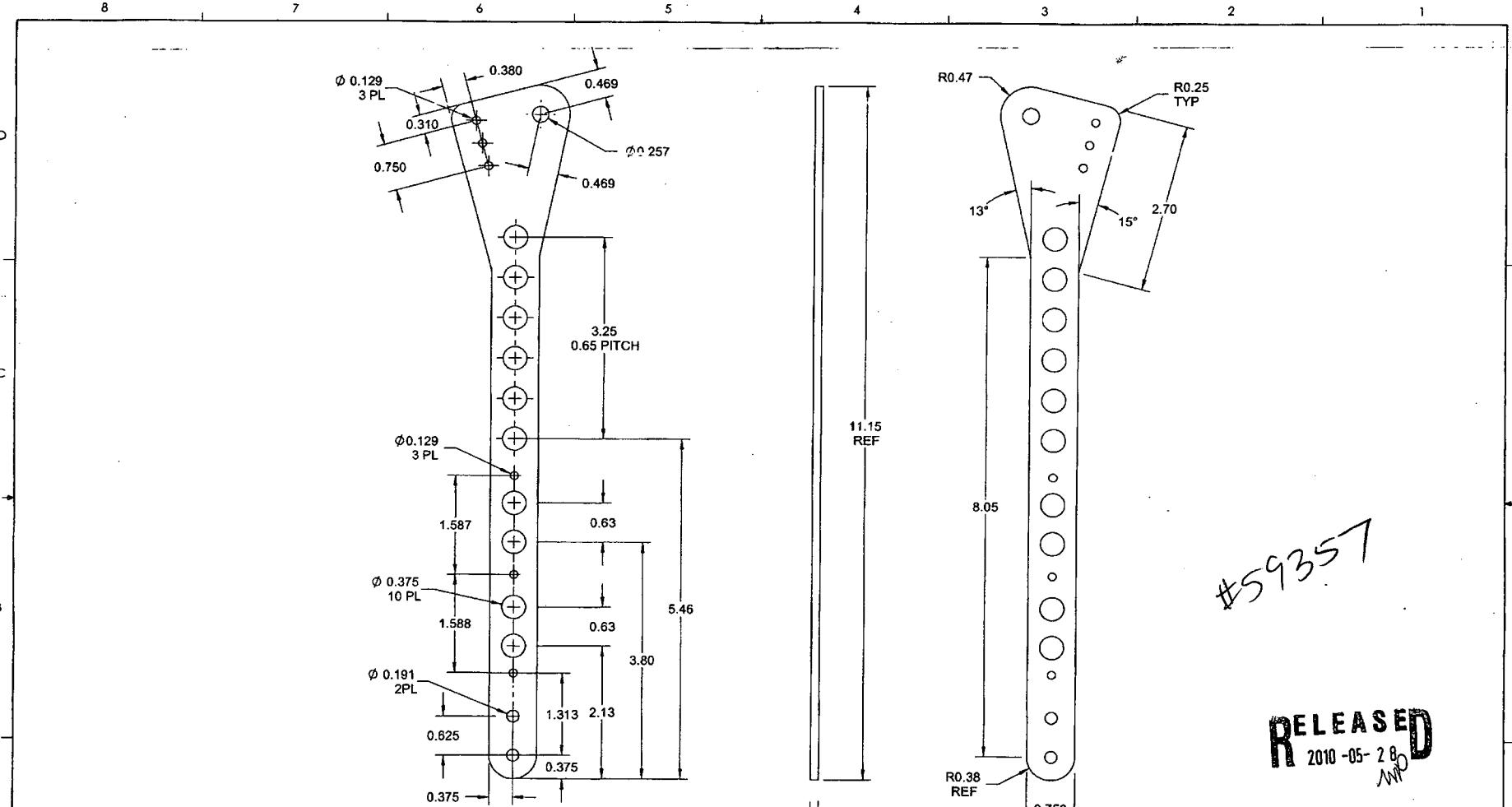
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NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.31 lbs

D3908-1 AFT X-TUBE LUG PLATE

DESIGN	JFH	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	REV. C
APPROVED	<i>[Signature]</i>	D3908
DE APPR.	<i>[Signature]</i>	SHEET 3 OF 5
DATE	10.05.27	TITLE
		SCALE
		NTS
		X-TUBE LUG ASSY (AFT)

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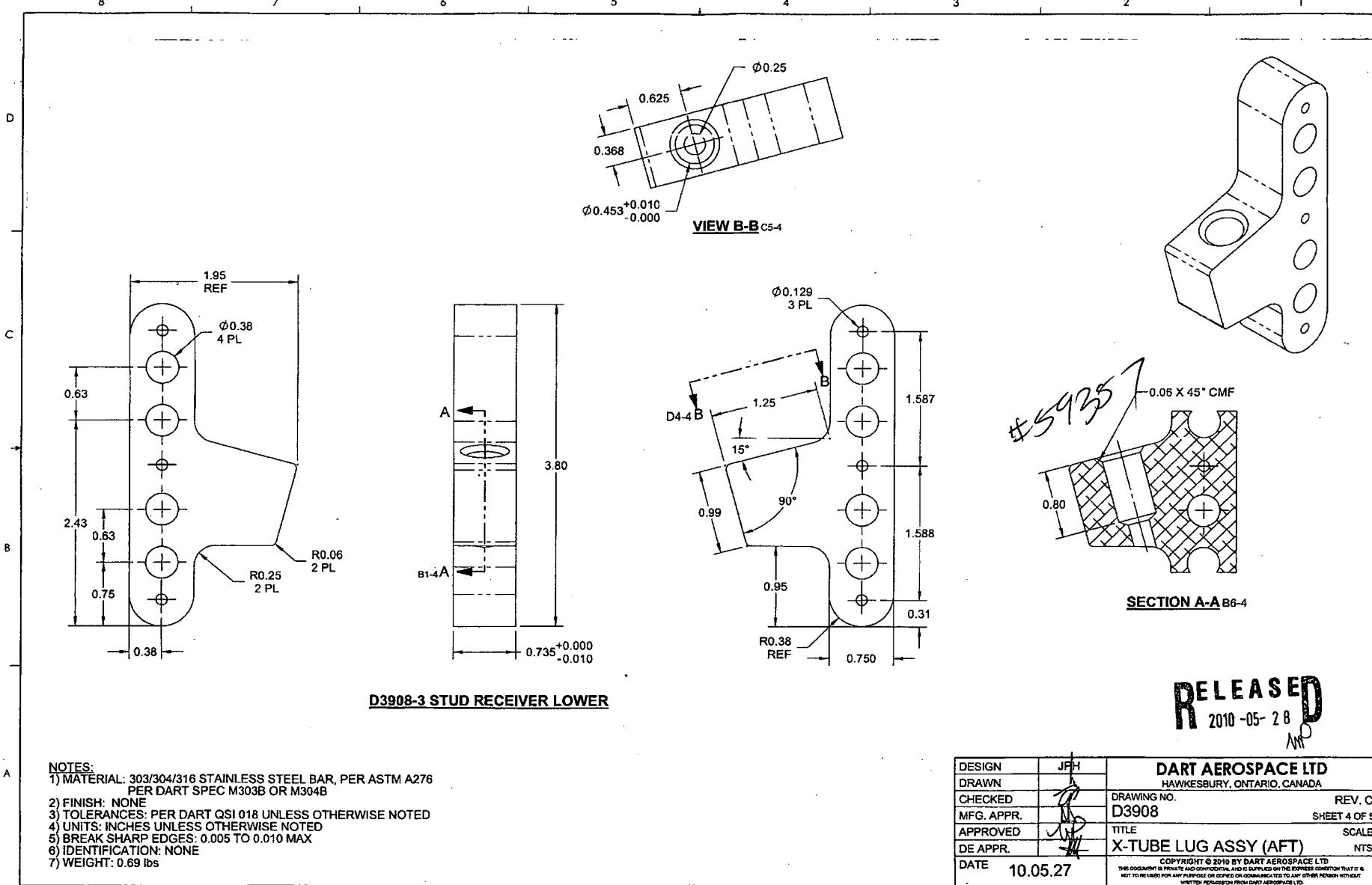
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8 7 6 5 4 3 2 1

D C B A

DESIGN	JPH	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. C
MFG. APPR.		D3908 SHEET 4 OF 5
APPROVED		TITLE
DE APPR.		SCALE
DATE	10.05.27	NTS

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RELEASED  
 2010-05-28

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8 7 6 5 4 3 2 1

D

D

C

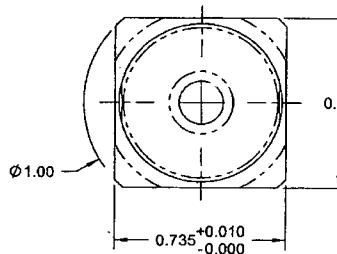
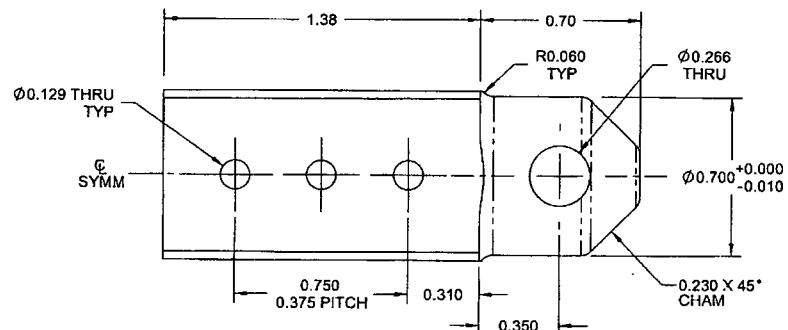
C

B

B

A

A



#59351

D3908-5 EYEBOLT STUD

RELEASED  
2010-05-28  
MR

## NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

8 7 6 5 4 3 2 1

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN	JA	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	NA	D3908	SHEET 5 OF 5
APPROVED	NA	TITLE	SCALE
DE APPR.	NA	X-TUBE LUG ASSY (AFT)	NTS
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